

Date: Monday, 5/1/2006 4:22:55 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 26910		
Estimate Number	: 10368		
P.O. Number	: <i>N/A</i>	Part Number	: D30481
This Issue	: 5/1/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3048 REV. A2
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 21457	Drawing Revision	: A2
	Type : SMALL /MED FAB	Material	: <i>N/A</i>
Written By	: <i>SRGA COMMENT Below</i>	Due Date	: 5/15/2006
Checked & Approved By	: <i>06.05.02</i>	Qty:	4 Um: Each
Comment	: Est: A 02.11.19 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 3.6312 sf(s)/Unit Total : 14.5249 sf(s)
 2024-T3 .063 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.063 thick
 (M2024T3S.063) Batch: *M19059*

FF 06.05.02

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blank: 13.935" x 32.500"

FF 06.05.02

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Make part per 1:1 flat pattern on Dwg D3048

FF 06.05.02

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06.05.02

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Form on CNC Brake per Dwg D3048

06.05.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 04/05/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AD 06/05/04 ①

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JB 06/05/04 ①

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

use for #26632 Z-Custom

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AD 06/05/05 ①

Job Completion



in 06/05/05

Dart Aerospace Ltd

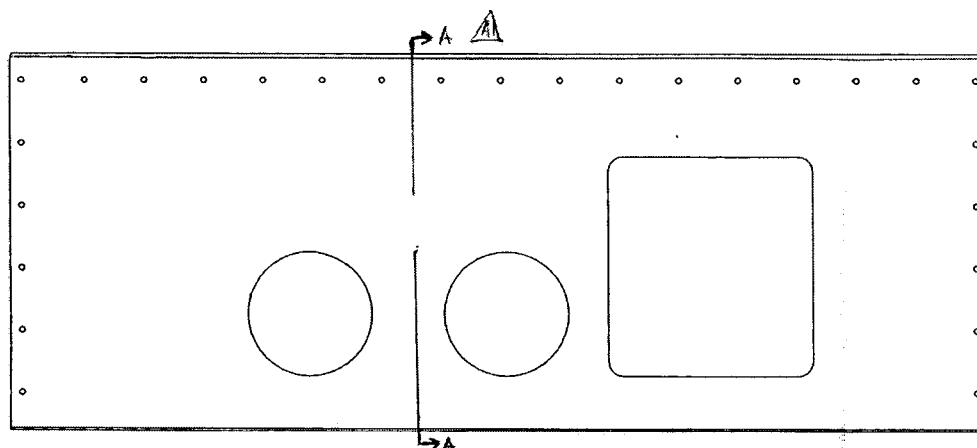
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

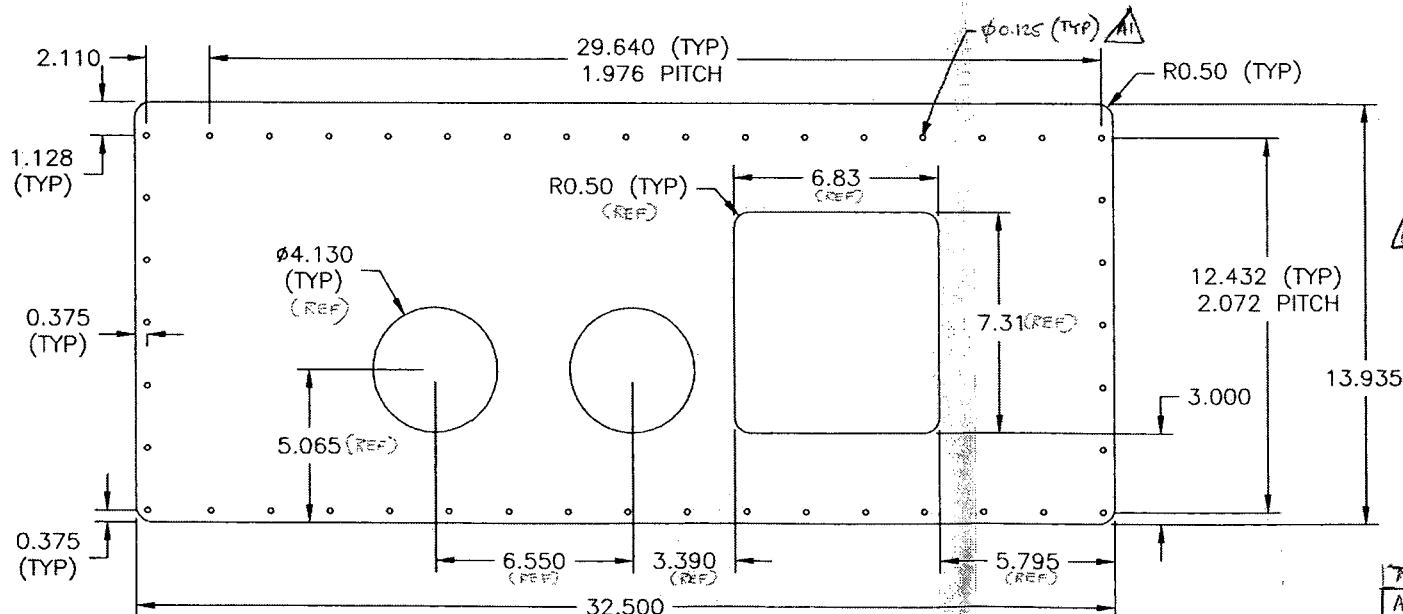
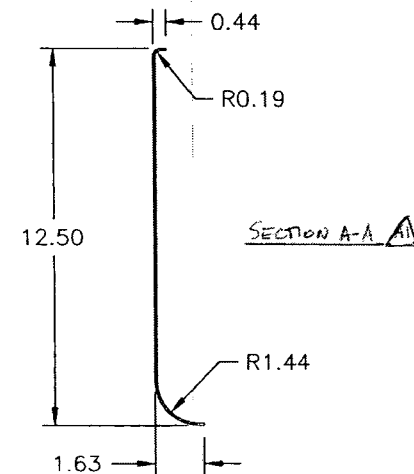
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3048-1



MATERIAL: 2024-T3 (QQ-A-250/4)
0.063 THICK
FINISH: ACID ETCH, ALODINE PER DART
QSI 005 4.1
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

△ CUT-OUTS (3 PLACES) ARE SHOWN FOR REFERENCE ONLY,
DO NOT CUT.



D3048-1 FLAT PATTERN

RELEASED
01.04.27

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
26910

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DART AEROSPACE LTD.

DESIGN #	01.09.25	REMOVE CUT-OUTS
AI	02.11.20	CORRECT DWG ERRORS
A	01.09.25	NEW ISSUE
DRAWN BY	RT	DART AEROSPACE LTD. HAMPSHIRE, ENGLAND
CHECKED	APPROVED	DRAWING NO. D3048
DATE	01.09.25	TITLE DOUBLER
		REV. A SHEET 1 OF 1 SCALE 1:4